

Work Order ID 81977

81977

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March-21-12 1:53:28 PM

Item ID: D3457-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Washer

Start Date: 21/03/2012 Start Qty: 60.00

60

Cust Item ID:

Required Date: 04/04/2012 Req'd Qty: 60.00

60

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/03/21 Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D3457 | Rev A | | | | | | | | |

100

0.00

100

DOOSAN LATHE

Doosan

Memo

0.00

Doosan Lathe

Turn as per Folio FA589 Rev: 44 & Dwg D3457 Rev: A

SL 12/3/27

60 ✓

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

SL 12/3/27

60 ✓

120

0.00

120

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

SL 12/03/28

60 ✓

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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NOTE: Date & initial all entries

Work Order ID 81977

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

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Start Date: 21/03/2012 Start Qty: 60.00

60

Cust Item ID:

Required Date: 04/04/2012 Req'd Qty: 60.00

60

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location

073

0.00

130

Packaging

Memo

0.00

Packaging

1143/28 (60)

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

12/3/2997MF
12-03-28

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 81977

81977

Parent Item: D3457-1

D3457-1

Parent Item Name: Washer

Start Date: 21/03/2012

Required Date: 04/04/2012

Start Qty: 60.00

Required Qty: 60.00

Comments: IPP A05.10.03New issueKJ/JLM
IPP Rev:B Now on Doosan Lathe 08-10-30 JLM Verified By:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

MDELRINR1.000

Purchased

No

100

f

43.0432

0.0208

1.313684

MDFI RINR1 000

**

Delrin Round Bar 1"

Location

Loc Qty

Loc Code

MAT055

43.0432

117985

0.407

118392

6.2762

119306

36.36

2.24

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

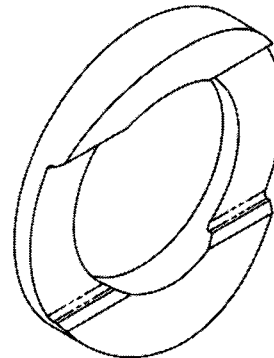


| | | | |
|------------------|----------------|--|------------------------|
| DESIGN CP | DRAWN BY CP | DART AEROSPACE USA, INC. PORT HADLOCK, WA | |
| CHECKED # | APPROVED # | DRAWING NO. D3457 | REV. A SHEET 1 OF 1 |
| DATE 05.09.06 | | TITLE WASHER | SCALE 2:1 |
| A | 05.09.06 | NEW ISSUE | |

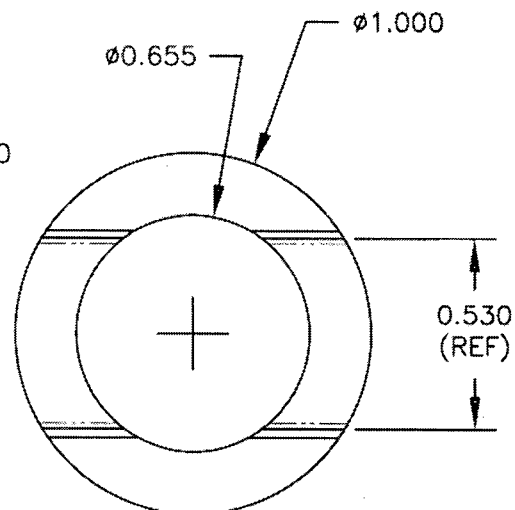
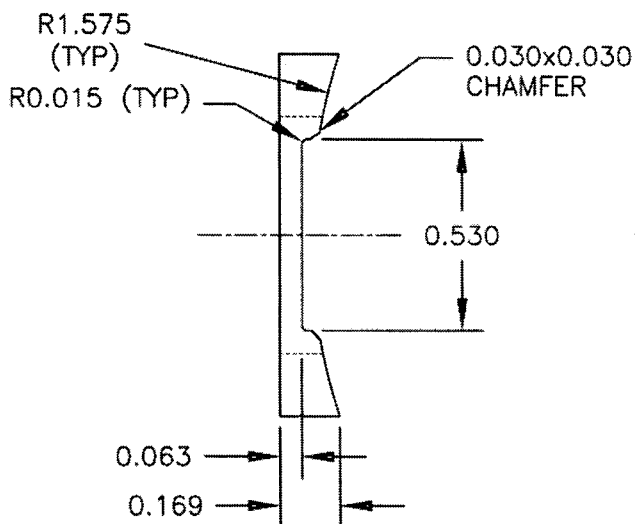
RELEASED
05.09.06

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 81922

112-03-21



ISOMETRIC DETAIL



D3457-1 WASHER

- 1) MATERIAL: DELRIN (DART SPEC. M-DELRIN-R)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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